

Work Order ID 57993

April 21, 2010 10:40:34 AM

Page 1

Item ID: D4039-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Aft Bracket

Start Date: 21/04/2010 Start Qty: 2.00

Required Date: 30/04/2010 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4039

A

PBX Rev.B

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut blank as per file D4039-3_BLANK

110

0.00



HAAS I

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLI FA881 AND DWG

FOLIO REV: AA

DWG REV: A

DEBURR

S.F 10/04/27

10-4-26

1

PTO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4039-3 PAR #: _____ Fault Category: prod eng cancel. NCR: (Yes) No DQA: ✓ Date: 10/06/02
 Resolution: Accepted Disposition: use as is QA: N/C Closed: ✓ Date: 10/11/24

NCR: <u>57993</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/04/27	110	Holes of .191 $\pm .005$ are oversized By .008" over tolerance they are at .204." <u>BE. Weung Drill on folio.</u>	<u>MP</u> 10/04/27 <u>QSG042</u>	<u>ACCEPTABLE</u> <u>MP</u> 10/04/27	<u>SL</u> 10/04/27	<u>SL</u> 10/04/28	<u>MP</u> 10/04/27 <u>QSG042</u>	<u>10/05/05</u> <u>S</u>
		<u>- R.C. W.D. 04/27</u>	<u>↓</u>	<u>→ Fix Fold And add copy of Folio as ref.</u>			<u>↓</u>	<u>S</u> 10/05/05
			<u>✓</u>	<u>ENG ERROR SEC ATTACHED.</u>	<u>QSG0505</u> 10-05-05		<u>✓</u>	

NOTE: Date & initial all entries

Work Order ID 57993

April 21, 2010 10:40:34 AM



Page 2

Item ID: D4039-3

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Setup Start



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Stop



Item Name: Aft Bracket

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Cust Item ID:

Required Date: 30/04/2010 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

SP 10/04/27

130

QC 8

0.00

QC

Memo

0.00

Quality Control

JL 10/04/28

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

HL 10/04/28

1

Ø

Work Order ID 57993

April 21, 2010 10:40:34 AM



Page 3

Item ID: D4039-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Bracket

Start Date: 21/04/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 30/04/2010 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

11/14207
START: 8:15am
Temp: 370°C
Fin: 8:45am

0.00

Powder Coating

160

QC3- Inspect Part Finish

0.00



QC

Memo

Quality Control

0.00

170

Identify as per dwg & Stock Location: _____

0.00

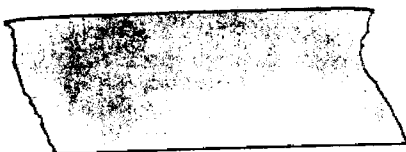


Packaging

Memo

Packaging

0.00



⇒ 10/04/29

ⓧ 1 ⓧ

⇒ m-1 10/04/29/ⓧ

10-4-29 5/ⓧ

Work Order ID 57993

April 21, 2010 10:40:34 AM



Page 4

Item ID: D4039-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Bracket

Start Date: 21/04/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 30/04/2010 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control



10/11/24 ~~10/05/24~~ JF

MF
10-11-24

POSITIVE RECALL

ECTIVE 10-06-02 AUTH JF

ASEL JF DATE 10-11-24

Picklist Print

April 21, 2010 10:40:33 AM

Page 1

Work Order ID: 57993

Parent Item: D4039-3

Parent Item Name: Aft Bracket

Comments: Ipp Rev:A New Issue 09-12-15 JLM Verified By:EC

Start Date: 21/04/2010

Required Date: 30/04/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.000X15.00 0		Purchased	No			100	f	6.5000	6.3158			

6061-T6 Bar 1.00 x 15.00

B10-4-26

D6102-005
JLM 10.05.04

Warehouse

Location

Main Warehouse

MAT07

9544

Loc Qty

6.5

6.5

Loc Code

\$33680

①

DART AEROSPACE LTD		Work Order: 57993
Description: Bracket		Part Number: D4039-3
Inspection Dwg: D4039	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.00	±.030	4.000	✓			
.19	±.030	.183	✓			
R.13	"	.125	✓			
1.00	TYP	1.000	✓			
.19	±.030	.186	✓			
3.73	"	3.733	✓			
.575	TYP	.576	✓			
6.000	±.010	5.995	✓			
.873	"	.871	✓			
2.250	TYP	2.245	✓			
.357	±.010	.362	✓			
1.125	TYP	1.130	✓			
Ø.391	+ .006 - .001	.394	✓			
Ø.191	+ .005 - .001	.204				
.561	±.010	.553	✓			
.200	"	.202	✓			
.730	+ .010 - .000	.732	✓			
Ø.261	+ .006 - .001	.264	✓			

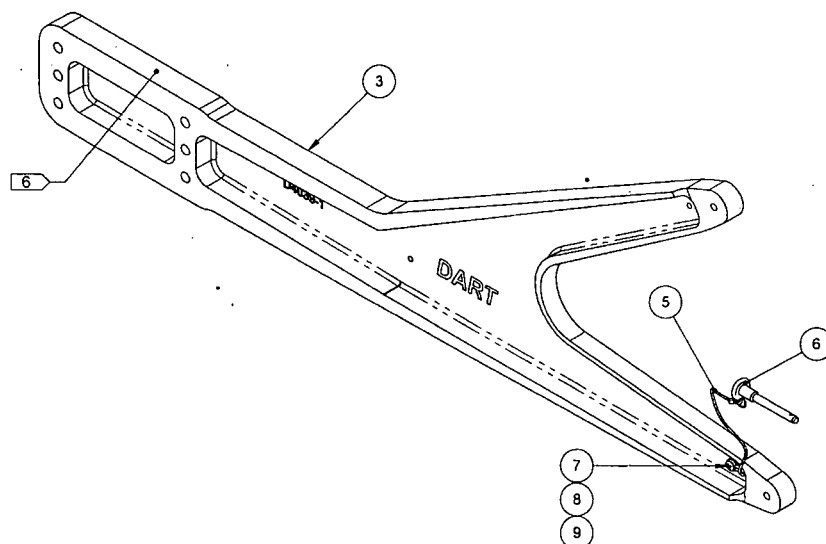
Measured by: S.P.
Date: 10/04/27

Audited by: SL
Date: 10/04/28

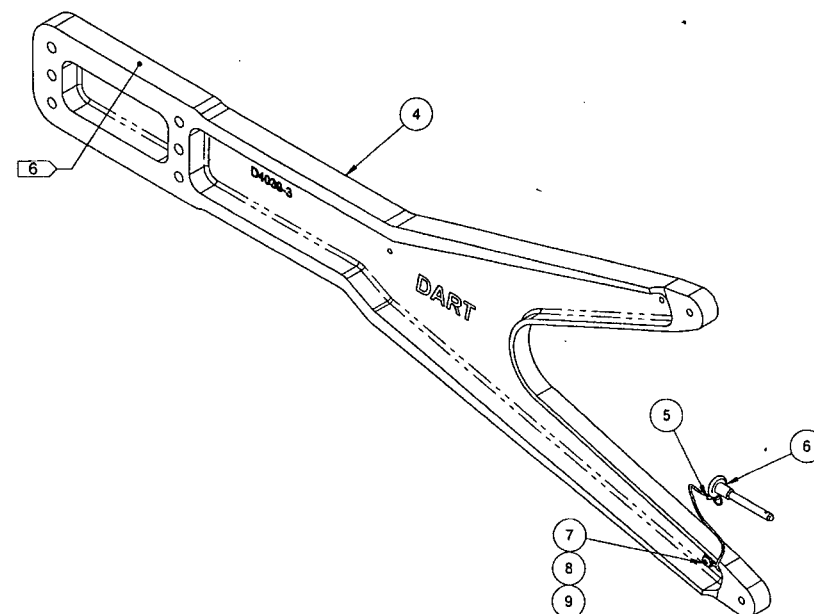
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

ITEM NO.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D4039-041	FWD BRACKET ASSEMBLY
2		X	D4039-043	AFT BRACKET ASSEMBLY
3	1		D4039-1	FWD BRACKET
4		1	D4039-3	AFT BRACKET
5	1	1	D2690-6	LANYARD
6	1	1	BLRS-010	PIP PIN
7	1	1	MS27039-1-11	SCREW
8	1	1	MS21042L3	NUT
9	3	3	NAS1149D0363J	WASHER



D4039-041 FWD BRACKET ASSEMBLY



D4039-043 AFT BRACKET ASSEMBLY

NOTES:

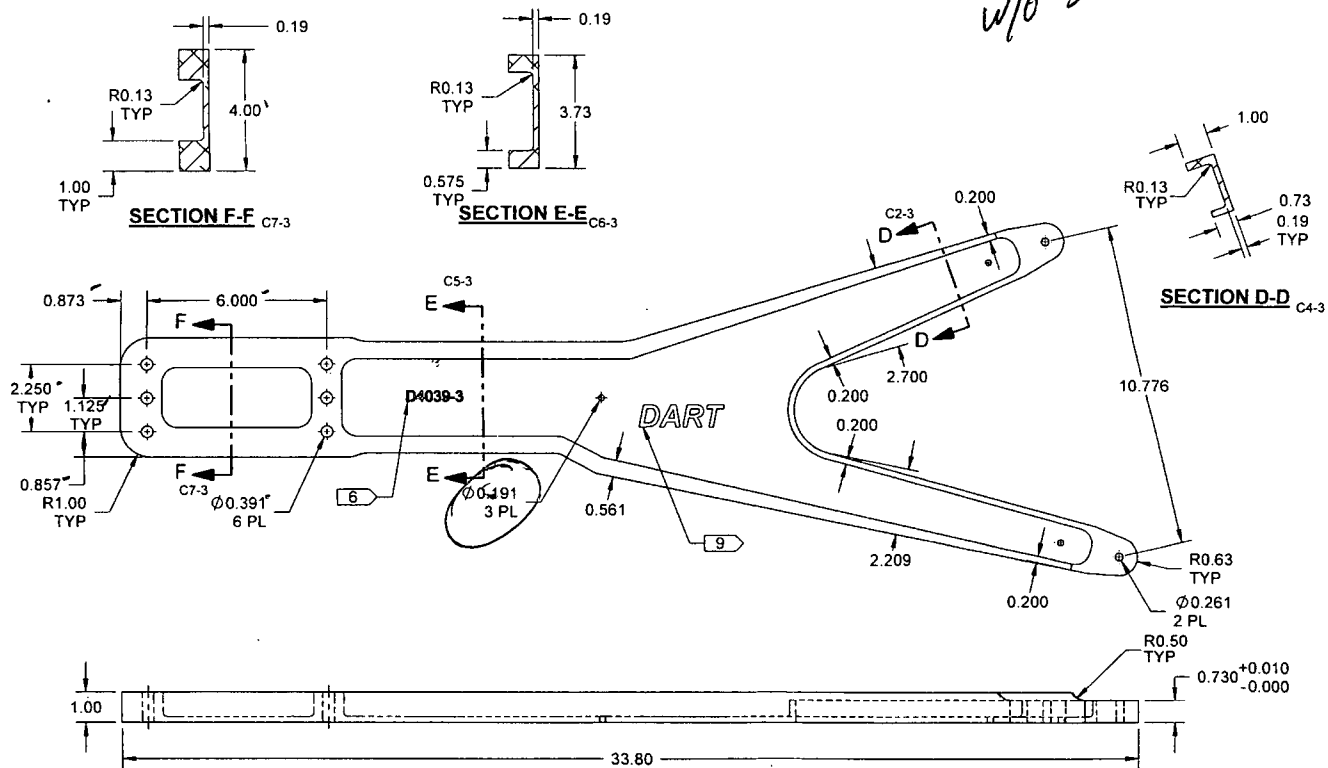
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4039-041/-043" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: N/A

A	NEW ISSUE		09.12.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.12.14		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4039	REV. A
TITLE BRACKET	SCALE NTS
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RELEASED
2010-04-14

w/o 57993



NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 1.000 THICK
PER AMS-QQ-A-250/11 (OR AMS 4025/4027)
REF DART SPEC M6061T6S1.000
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AND BATCH NUMBER IN THIS AREA TO MAX
DEPTH OF 0.010 WITH MIN TOOL RADIUS OF 0.010
- 7) WEIGHT: 6.23 lbs
- 8) MACHINE PER DART SOLIDWORKS PART "D4039-3. REVA.SLDPRJT"
- 9) ENGRAVE DART LOGO IN THIS AREA TO MAX DEPTH OF 0.015 WITH MIN TOOL RADIUS OF 0.250

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4039	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
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RELEASED
2010-04-14
AWP

Mike Petsche

From: David Shepherd [dshepherd@dartaero.com]
Sent: April 27, 2010 3:49 PM
To: 'Mike Petsche'
Subject: RE: Sent from Snipping Tool
Attachments: image001.png

Mike,

This is an acceptable deviation.

David

From: Mike Petsche [mailto:mpetsche@dartaero.com]
Sent: Tuesday, April 27, 2010 1:45 PM
To: 'David Shepherd'
Subject: Sent from Snipping Tool

Holes circled in red. New dwg says dia: 0.191. Old dwg has the them at 0.203

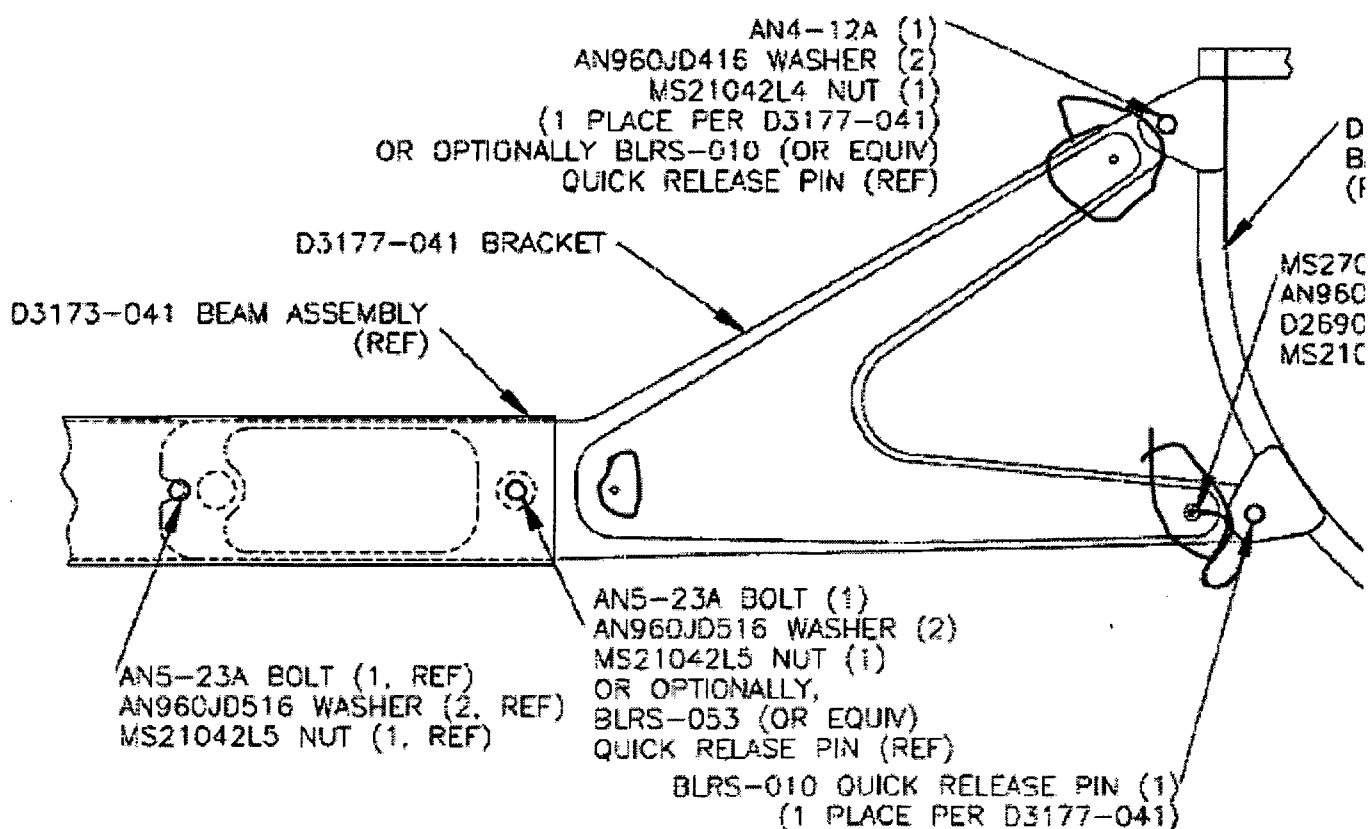


Figure 3 – D3177-041 Fwd Bracket Attachmen

Jean-Luc Menard

From: Harvey Siemens [hsiemens@dartaero.com]
Sent: April 28, 2010 11:27 AM
To: 'Jean-Luc Menard'; 'Mike Petsche'
Cc: 'Marc Bellavance'
Subject: RE: D4039 Rev. PB1

Thank you all for your quick reply. The rest of the paperwork will be coming your way shortly.

JL

I think that the hole that I dimensioned at 0.191 was the only hole in the model that was that size. Weird since the model is based on the "other" Y brackets.

Regards,

Harvey Siemens

Mechanical Designer
DART Aerospace Ltd.

P: 403-717-0328
 F: 403-717-1288
 E: hsiemens@dartaero.com
 W: www.dartaero.com

M: 1060 McTavish Road NE, Calgary, Alberta, T2E 7G6

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From: Jean-Luc Menard [mailto:jmenard@dartaero.com]
Sent: Wednesday, April 28, 2010 9:17 AM
To: 'Harvey Siemens'; 'Mike Petsche'
Cc: 'Marc Bellavance'
Subject: RE: D4039 Rev. PB1

Looks good, I don't know what happened, the original parts made in December were both drilled at .203"?????
 As long as its fixed,
 Thx
 JLM

From: Harvey Siemens [mailto:hsiemens@dartaero.com]
Sent: April 28, 2010 11:11 AM
To: Mike Petsche
Cc: 'Marc Bellavance'; Jean-Luc Menard
Subject: D4039 Rev. PB1

Hey guys,

Talked with JL this morning and he raised an inconsistency between the D4039-1 and the -3 regarding the hole

06/05/2010

sizes. This discrepancy has been corrected. Since you were the original reviewers, I am forwarding the prelim drawing to you. Thank you for your time in going over the attached drawing. Let me know if there are any other details that need to be changed or adjusted.

If everybody is good with it (let me know) I'll revise the MDL and issue an ECN. David will approve shortly after that and you'll have an updated drawing.

JL

Thought about Section A-A and D-D and the 0.73 dimension that is shown there vs the $0.730 +0.010/-0.000$ dimension shown in zone B3. The B3 dimension is for the lug at the end while the section view dimension is just for that shorter leg of the beam. I think the way we have it dimensioned is correct. We want to maintain a tight tolerance on the lug but the shorter leg portion is not so critical. Let me know if that explanation doesn't make sense.

Regards,

Harvey Siemens

Mechanical Designer

DART Aerospace Ltd.

P: 403-717-0328

F: 403-717-1288

E: hsiemens@dartaero.com

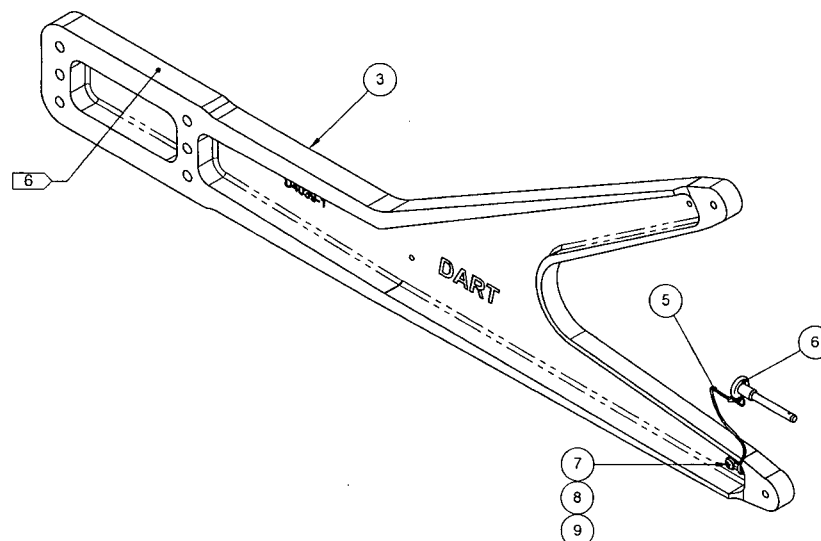
W: www.dartaero.com

M: 1060 McTavish Road NE, Calgary, Alberta, T2E 7G6

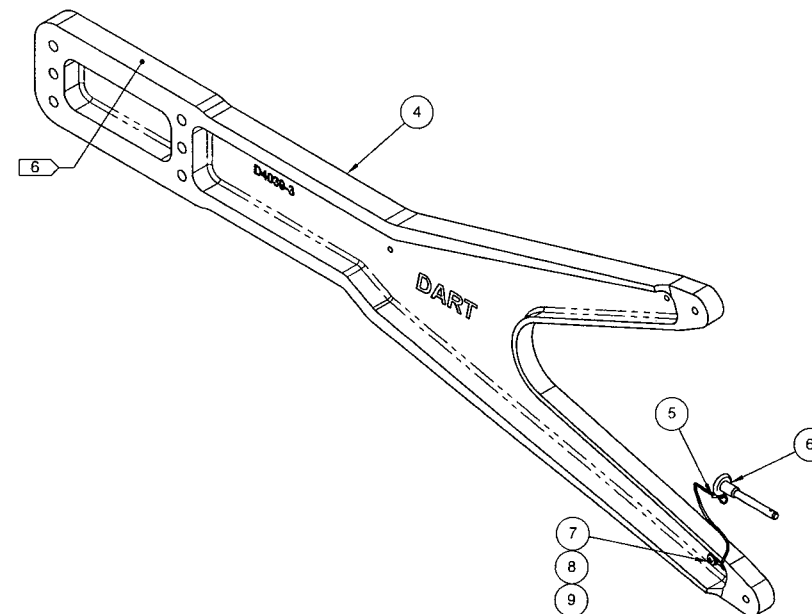
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06/05/2010

ITEM NO.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D4039-041	FWD BRACKET ASSEMBLY
2		X	D4039-043	AFT BRACKET ASSEMBLY
3	1		D4039-1	FWD BRACKET
4		1	D4039-3	AFT BRACKET
5	1	1	D2690-6	LANYARD
6	1	1	BLRS-010	PIP PIN
7	1	1	MS27039-1-11	SCREW
8	1	1	MS21042L05	NUT
9	3	3	NAS1149D0363J	WASHER



D4039-041 FWD BRACKET ASSEMBLY



D4039-043 AFT BRACKET ASSEMBLY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4039-041/-043" AND B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: N/A

PRELIMINARY ISSUE

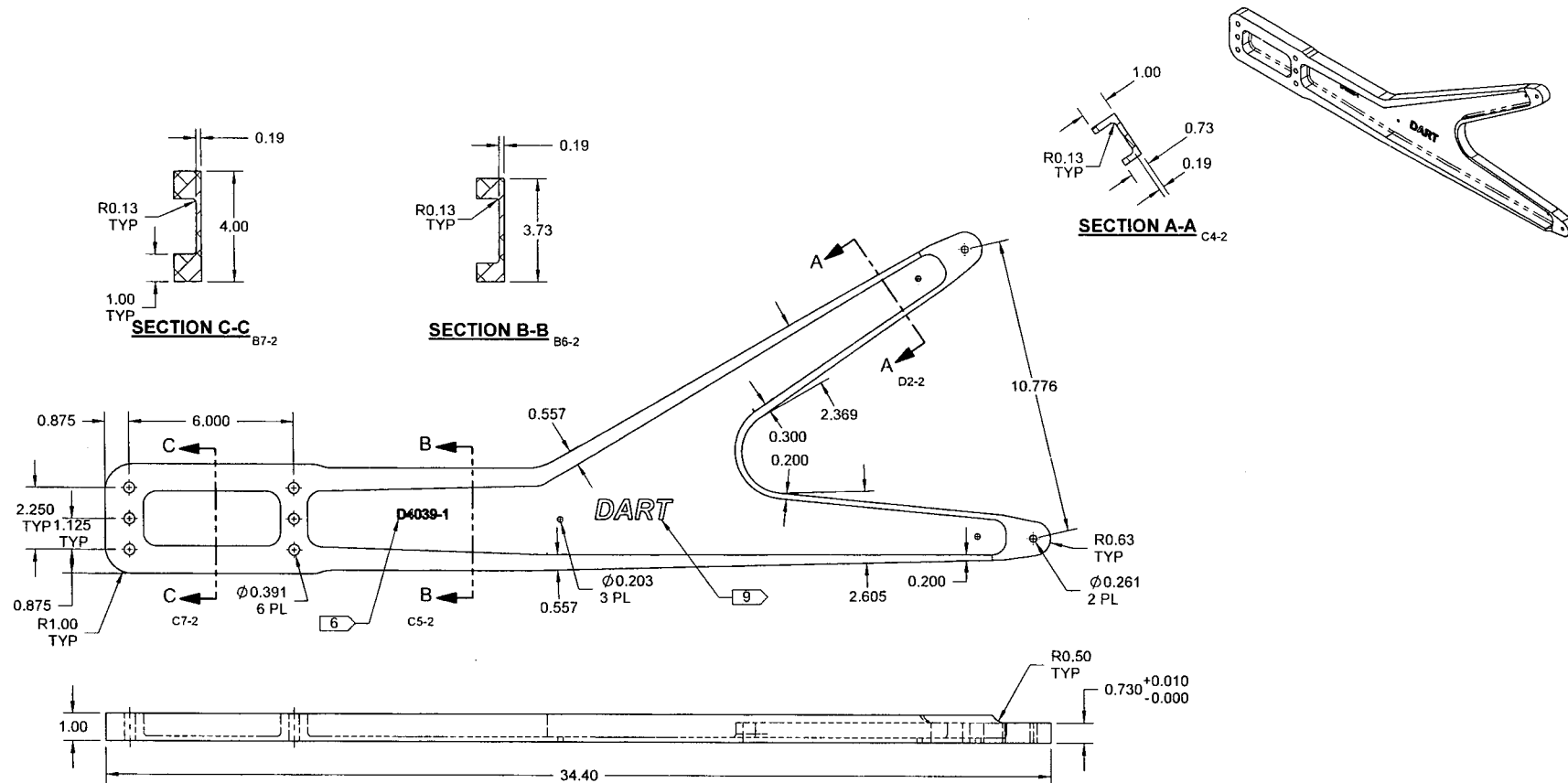
10.04.28

PB1	REVISE HOLE SIZE ON D4039-3 FROM 0.191 TO 0.203, ZN	HS	10.04.28
A	NEW ISSUE	HS	09.12.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.04.28		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4039** REV. PB1
SHEET 1 OF 3
TITLE **BRACKET** SCALE NTS

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D4039-1 FWD BRACKET

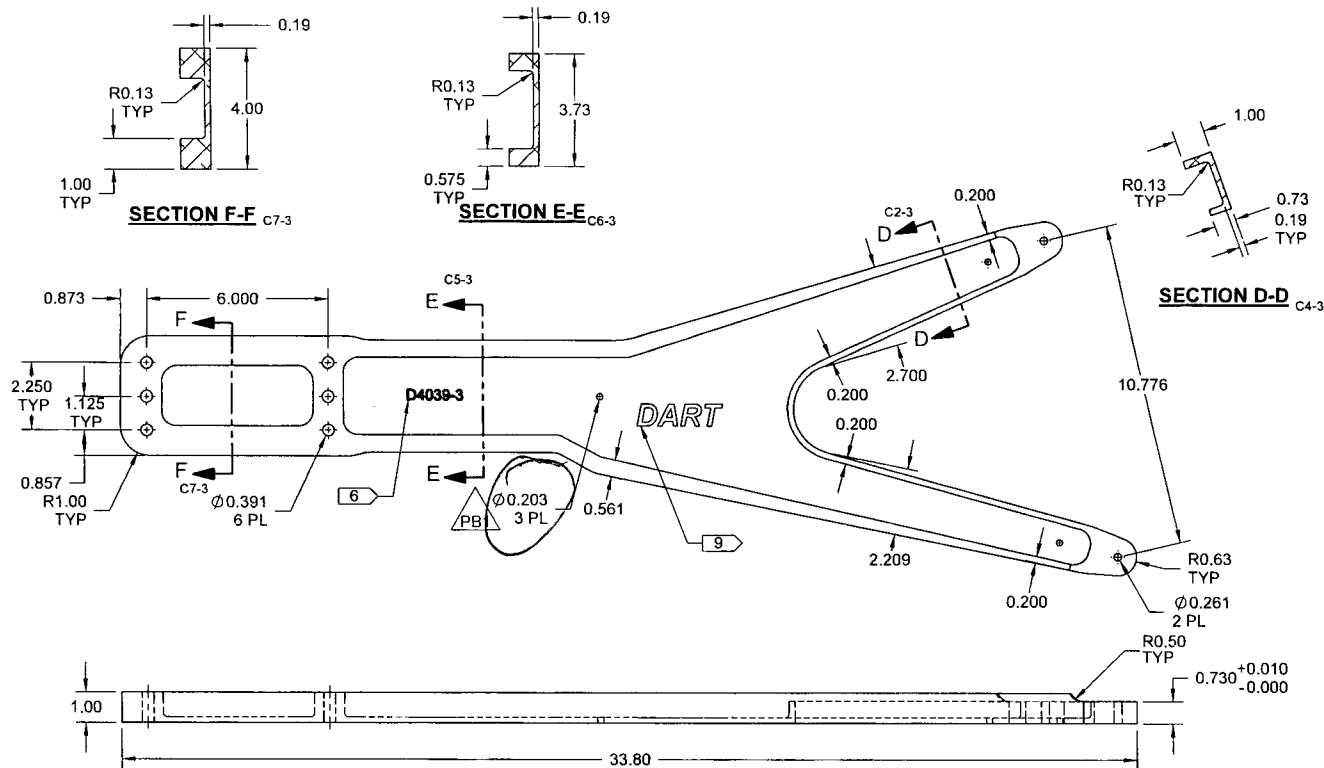
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 1.000 THICK
PER AMS-QQ-A-250/11 (OR AMS 4025/4027)
REF DART SPEC M6061T6S1.000
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AND BATCH NUMBER IN THIS AREA TO MAX
DEPTH OF 0.010 WITH MIN TOOL RADIUS OF 0.010
- 7) WEIGHT: 6.64 lbs
- 8) MACHINE PER DART SOLIDWORKS PART "D4039-1_REVA.SLDPRT"
- 9) ENGRAVE DART LOGO IN THIS AREA TO MAX DEPTH OF 0.015 WITH MIN TOOL RADIUS OF 0.250

PRELIMINARY ISSUE

10.04.28

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. PB1
MFG. APPR.		D4039 SHEET 2 OF 3
APPROVED		TITLE SCALE
DE APPR.		BRACKET NTS
DATE	10.04.28	COPYRIGHT © 2009 BY DART AEROSPACE LTD
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D4039-3 FWD BRACKET

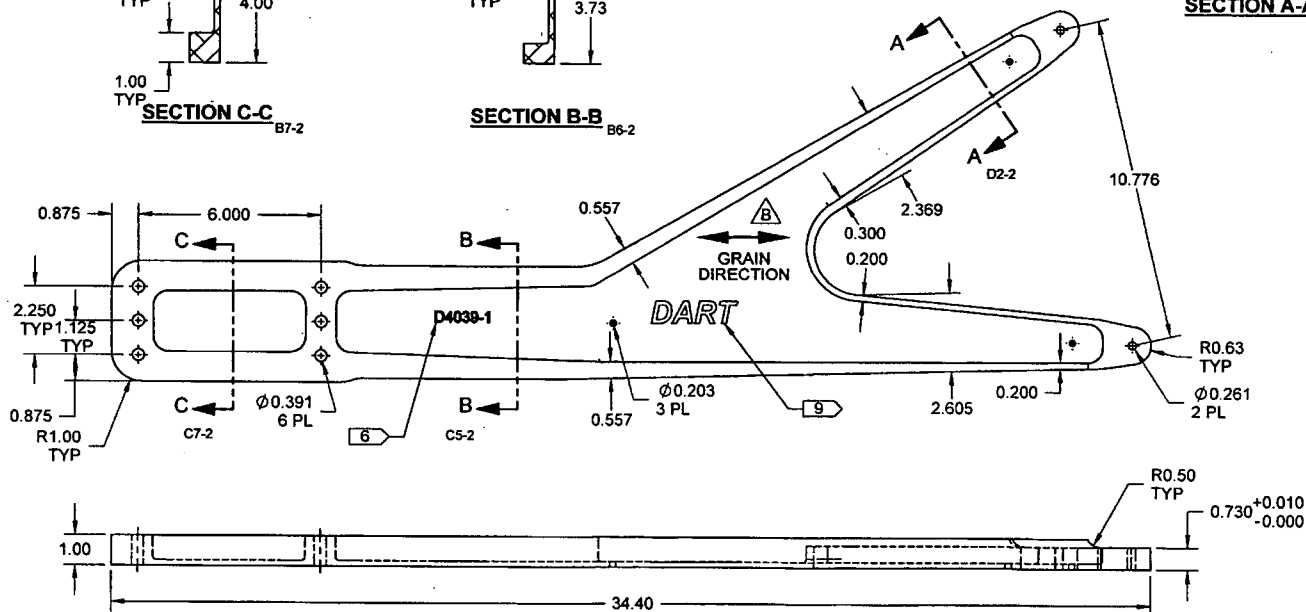
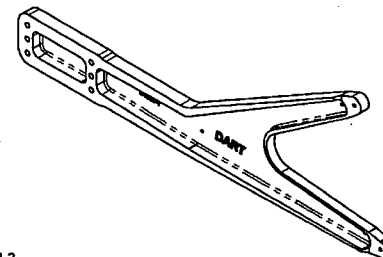
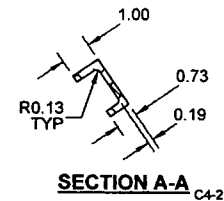
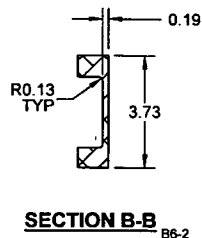
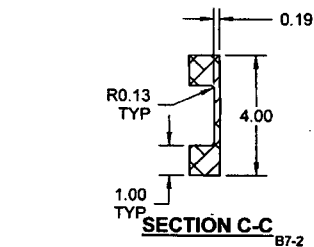
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 1.000 THICK
PER AMS-QQ-A-250/11 (OR AMS 4025/4027)
REF DART SPEC M6061T6S1.000
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AND BATCH NUMBER IN THIS AREA TO MAX
DEPTH OF 0.010 WITH MIN TOOL RADIUS OF 0.010
- 7) WEIGHT: 6.23 lbs
- 8) MACHINE PER DART SOLIDWORKS PART "D4039-3 REVA.SLDPRT"
- 9) ENGRAVE DART LOGO IN THIS AREA TO MAX DEPTH OF 0.015 WITH MIN TOOL RADIUS OF 0.250

PRELIMINARY ISSUE

10.04.28

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PB1
MFG. APPR.		D4039	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	10.04.28	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR CLIPED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D4039-1 FWD BRACKET

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 1.000 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S1.000
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AND BATCH NUMBER IN THIS AREA TO MAX
DEPTH OF 0.010 WITH MIN TOOL RADIUS OF 0.010
- 7) WEIGHT: 6.64 lbs
- 8) MACHINE PER DART SOLIDWORKS PART "D4039-1 REV.B.SLDPRJT"
- 9) ENGRAVE DART LOGO IN THIS AREA TO MAX DEPTH OF 0.015 WITH MIN TOOL RADIUS OF 0.250

RELEASED
2010-09-27

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4039	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	10.04.28	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	